

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11)

EP 0 699 168 B2

(12)

NEW EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the opposition decision:

21.05.2003 Bulletin 2003/21

(45) Mention of the grant of the patent:

29.01.1997 Bulletin 1997/05

(21) Application number: 95902268.2

(22) Date of filing: 05.12.1994

(51) Int Cl.7: **B65H 19/29, B05C 1/02**

(86) International application number:

PCT/IT94/00202

(87) International publication number:

WO 95/015902 (15.06.1995 Gazette 1995/25)

(54) **DEVICE FOR GLUING THE TAIL END OF A REEL OF WEB MATERIAL**

VORRICHTUNG ZUM ANKLEBEN DES FREIEN ENDES EINER ROLLE AUS BAHNMATERIAL

DISPOSITIF D'ENCOLLAGE DE L'AMORCE D'UN ROULEAU DE MATIERE EN BANDE

(84) Designated Contracting States:

AT CH DE ES FR GB GR IT LI NL SE

(30) Priority: 10.12.1993 IT FI930254

(43) Date of publication of application:

06.03.1996 Bulletin 1996/10

(73) Proprietor: **FABIO PERINI S.p.A.**

I-55100 Lucca (IT)

(72) Inventor: **BIAGIOTTI, Guglielmo**

I-55012 Capannori (IT)

(74) Representative: **Mannucci, Gianfranco, Dott.-Ing.**

Ufficio Tecnico Ing. A. Mannucci

Via della Scala 4

50123 Firenze (IT)

(56) References cited:

EP-A- 0 481 929

DE-A- 1 511 076

DE-A- 1 632 170

GB-A- 1 495 445

GB-A- 2 098 092

JP-A- 5 035 562

US-A- 4 102 304

US-A- 5 242 525

EP 0 699 168 B2

Description**Technical field**

[0001] The invention relates to a device for gluing the tail end of a reel or log of wound web material according to the preamble of claim 1, of the type comprising: conveying means for moving the reel; unwinding means for unwinding the tail end of the web material; a dispenser of glue for applying a glue to the web material of the reel; and means for rewinding the reel after the glue has been applied. More particularly, the invention relates to a device of the above type in which the glue is applied to a portion of material still wound on the reel and onto which the tail or outer end is then rewound.

[0002] Such devices are commonly used in the paper converting industry, wherein large paper coils (parent rolls) are unwound and rewound to form reels or logs of smaller diameters. The tail end of these reels is glued after rewinding and the reels are thereafter subject to further operations, such as cutting along planes perpendicular to the reel axis, in order to produce toilet paper rolls, all purpose wipers rolls, kitchen rolls or the like.

State of the art

[0003] Various kinds of reel gluing devices exist, and, purely by way of illustration, those disclosed in, for example, US-A-4 475 974, US-A-4 963 223, EP-A-0 481 929 and US-A-5 242 525 may be indicated. In all currently known gluing devices, and in particular in those disclosed in the patents cited above, the unwinding of the tail end of the web material before gluing takes place is achieved by holding the reel in an unwinding position and striking said reel with blasts of air emitted by nozzles in suitable positions and orientations. These blasts of air lift the tail end of the reel and open it onto a supporting surface. The reel is then made to rotate in order partly to rewind the tail end so that a predetermined and limited length of web material remains on the supporting surface. Once this has been done it is necessary to transfer the reel with the tail end in this position to the glue dispenser. In conventional gluing devices, disclosed for example in US-A-4 963 223 or in US-A-4 475 974, the reel is transferred by translationally moving a pair of rolls on which the reel is supported and, integrally with said rolls, the surface on which the tail end has been unwound. This is necessary because the glue is dispensed through nozzles directly onto the tail end which is then rewound onto the reel. In order to considerably simplify the gluing process, EP-B-0 481 929 discloses a novel gluing process, in which once the tail end has been unwound from the reel, the reel is rolled over a slit through which the glue is dispensed. This makes it possible to achieve major simplifications and to greatly reduce maintenance, if not eliminate it altogether.

[0004] JP-A-5035562 discloses a gluing device wherein the reel is placed on a pair of rollers. The tail

end of the web material is then unwound and glue is applied on the outer surface of the reel either by means of nozzles or by means of a moving bar.

[0005] The present invention relates to a tail sealer using the same method as disclosed in EP-B-0 481 929, with a modified glue dispenser.

Disclosure of the invention

[0006] The features of the gluing device according to the invention are set forth in claim 1.

[0007] The features of the method according to the invention are set forth in claim 7.

[0008] Basically, the device according to the invention comprises a glue dispenser which includes a glue container with at least one upwardly oriented slit from which glue is dispensed, wherein inside said container a moving member is positioned, which is cyclically immersed in the glue and moved toward the upwardly oriented slit in order to apply the glue on the reel which rolls over said slit.

[0009] In a particularly advantageous embodiment, said container is upwardly closed by a rolling surface on which the reels to be glued are made to roll, said surface being provided with said at least one upwardly oriented slit.

[0010] According to an embodiment of the invention, the movable member is formed by a transversely extending, substantially rectilinear bar. Said movable member may be provided with an upwardly oriented concave surface, in which the glue is collected.

[0011] Further advantageous features of the invention are set forth in the appended claims.

[0012] The invention also relates to a method for gluing the outer end of a web material wound on a reel, wherein: the outer end of the web is unwound or detached from the reel by a predetermined extent; the glue is applied on a region of the web material which is still wound up on the reel by rolling said reel, with the outer end being unwound therefrom, along a rolling surface and over a slit from which the glue is dispensed; and the outer end is rewound on the reel while the reel is rolling along the rolling surface. While the reel is rolling over the upwardly oriented slit, glue is dispensed therefrom by a movable member which is cyclically immersed into a glue container to pick up a certain amount of glue.

Brief description of the drawings

[0013] The invention will be understood more clearly from a perusal of the description and enclosed drawing, the latter showing a practical, non-limiting embodiment of the invention. In the drawing:

Fig. 1 shows a side view of the device according to the invention;

Fig. 2 shows an enlarged side view and partial longitudinal section of the glue dispensing area of the

device;

Fig. 3 shows a cross section according to line III-III in Fig. 2; and

Fig. 4 shows a modified embodiment.

Detailed description of the invention

[0014] The device according to the invention comprises an entry chute 1, on which the reels L arrive in succession from a re-reeling machine positioned upstream of the device, and not shown. In the accompanying figures the reels L are of the type having a central winding core, but it is obvious that the working of the device of the present invention will not be changed if it is used for gluing reels that have no central winding core.

[0015] The numeral 3 indicates a feeder rotating about an axis A, which transfers one reel at a time from the chute 1 to a supporting and conveying surface indicated as a whole by the numeral 5. Downstream of the feeder 3, the surface 5 comprises an aperture from which the upper surface of an unwinding roll 7, rotating about a fixed axis marked B, projects slightly. Downstream of the unwinding roll 7 (which in the example illustrated rotates anticlockwise) is a vacuum space 9 leading down underneath the surface 5. Positioned downstream of the mouth of the space 9 is the glue dispenser, indicated 11 as a whole. The dispenser is positioned underneath a dispensing aperture or slit 155 formed along the supporting and conveying surface 5. The latter then continues towards the reel discharge area where there are collecting means (not shown) which take the glued reels and transfer them to the cutting machine which cuts up the individual reels into a plurality of rolls of predetermined height.

[0016] Above the supporting and conveying surface 5 is an assembly 15 suspended by a chain 16 at a height that can be adjusted to suit the dimensions of the reels L for the purposes indicated below. The assembly 15 carries a pair of rolls 17, 19 around which a flexible drive 21, consisting of one or a series of belts or the like travels. The flexible drive 21 has a lower half 211 that runs approximately parallel with the reel supporting and conveying surface 5. The distance from the lower half 211 to the surface 5 is adjustable by means of a system comprising a handwheel 23 and a speed-reducing mechanism 25, by means of which the assembly 15 can be moved vertically, guided laterally by means of rolls 27 and relevant tracks. The handwheel 23 and the speed-reducing mechanism 25 may also be replaced by a geared-down motor or the like.

[0017] Between the upper and lower halves of the flexible drive 21 is a pressure roll 29 mounted on a unit 31 which in turn is supported by links 33, 35 connected to a springloaded member 37 which pushes the pressure roll 29 down against the lower half 211 of the flexible drive 21. The unit 31 has a slot 31 A along which the pressure roll 29 can be positioned in order to alter its position relative to the glue dispenser 11.

[0018] Communicating with the vacuum space 9 is a vacuum box 51 connected to a vacuum line (not shown). The vacuum box 51 extends across approximately the entire width of the device, at right angles to the plane of the figures, and has an opening or a plurality of openings 53 permitting communication between the box 51 and the vacuum space 9. The openings 53 are located in the lower part of the vacuum space 9.

[0019] Each individual reel L is taken from the chute 1 by the rotating feeder 3 and unloaded onto the supporting and conveying surface 5. The rotation of the feeder 3 about its axis A forces the reel between the supporting and conveying surface 5 and the lower half 211 of the flexible drive 21. Said flexible drive is driven in the direction shown by the arrow f21 by one of the rolls 17, 19, which for this purpose is powered in some way. Thus the reel L is rolled in a controlled manner along the first portion of the supporting and conveying surface 5. After rolling a certain distance over the surface 5, the reel L comes into contact with the upper portion of the unwinding roll 7, which projects from the surface 5. This is shown in Fig. 2. When the reel reaches this position, it begins to rotate about its axis, clockwise in the drawing, while remaining in the same position. This is obtained by moving the belts 21 at the same speed as the roll 7. Meanwhile the vacuum space 9 is in depression because of the suction exerted by the vacuum box 51. Consequently, when the tail end LF appears on the right hand side (in Fig. 2) of the reel L, it is detached from the external surface of the reel L, unwound from it and sucked into the vacuum space 9. Fig. 2 shows the tail end LF as it first comes away from the external surface of the reel L while Fig. 1 shows the position assumed by the tail end LF once sucked into the vacuum space 9. The roll 7 continues to rotate even when the tail end LF is inside the vacuum space 9 and therefore said end is gradually drawn out and rewound onto the reel L until the terminal edge of the tail end LF is in front of a sensor, which may be optical or the like. The position of the sensor can be adjusted to alter the length of tail end unwound. Alternatively (or in combination), the adjustment of the length of the tail end can be brought about by appropriately delaying the stopping of the rotating of the roll 7 relative to the signal from the sensor. This sensor, when it detects the position of the tail end, stops the roll 7 from rotating, thereby causing the reel to advance in a controlled manner and to rotate on the surface 5 over the aperture 155 of the dispenser 11. The controlled movement of the reel is obtained by means of belt 21 which continues to move at constant speed. In this way the glue is applied to the reel in the location uncovered by the partial unwinding of the tail end LF.

[0020] As the translation movement of the lower half 211 of the flexible drive 21 is continued, the reel is caused to roll in a controlled manner along the supporting and conveying surface 5 to a position underneath the pressure roll 29, which presses on the surface of the

reel at the point where the tail end is to be stuck. The position of the pressure roll 29 is adjusted so as to act on the reel at the point where the glue has been applied, in order to guarantee a better closure without it being necessary to hold the reel in position, causing it to execute a complete revolution in this location.

[0021] The glued reel is subsequently discharged and a new reel is being processed in position L for its free end to be opened.

[0022] Figs 2 and 3 show the details of the glue dispenser 11. The dispenser 11 comprises a container 151 containing the glue C. The container is upwardly closed by a wall 153 with a dispensing slit or dispensing aperture 155 which opens in the surface 5 on which the reels are made to rotate. Inside the container 151 is a moving member 157 consisting of a transverse bar 159 hinged at 161 and 163 (Fig.3) to a set of rockers, the first and the last of which are shown in Fig.3, and designated 165, 167. The rockers are hinged at 169 and 170 to the wall of container 151. The bar 159 is connected, via a joint 173 to the shaft 175 of a cylinder-piston actuator 177. The actuator 177 generates a pivoting movement of rockers 165, 167 and thus a movement of bar 159 from the position shown in solid line in Fig.3 to the position shown in broken lines and designated 159X in Fig.3.

[0023] Upwardly the bar 159 is provided with a concave surface 157S which is in practice a longitudinal channel extending substantially along the whole length of the bar 159. When the bar is in its lower position, the surface 157S is immersed in the glue C, such that the subsequent lifting of the bar 159 caused by actuator 177 determines the lifting of a certain amount of glue which is collected in the channel formed by surface 157S. The dimension of the channel defines the amount of glue which is picked up by bar 159 at every stroke. The motion of bar 159 is synchronized with the feeding motion of the reels in such a way that the bar 159 is in its upper position when the reel L is made to roll along the supporting and rolling surface 5 over the dispensing aperture 155. When it rolls over the dispensing aperture 155 the reel collects the glue from the surface 157S and, continuing to roll its tail end is glued on the outer surface of the reel.

[0024] Fig.4 shows a modified embodiment of the dispenser of Figs 2 and 3. In this embodiment the moving member 157 is supported by an oscillating arm 181 hinged at 183 to a transverse axis. The functioning of the dispenser of Fig.4 is similar to that of the dispenser of Figs. 2 and 3, the arm 181 being controlled e.g. by a brushless electric motor or other actuator, such as a fluid cylinder arranged outside the container 151. The arm could be shorter and made to continuously or intermittently rotate about a transverse axis arranged under the glue dispensing aperture.

[0025] The dispenser 11 has been described hereinabove in combination with a particular kind of reel feeding and tail end unwinding system. However, it should be understood that the same dispenser can be com-

bined with different reel feeding and tail end unwinding means. In particular, it can be used in tail sealers of the kind described in EP-A-0.481.929 or US-A-5.242.525. It is also possible to adopt other reel moving and tail unwinding means, such as those used in tail sealers models N. 65.30, 65.31 and 65.40 (US-A-4,963,223) produced by the applicant, wherein the reels are moved from the tail unwinding station to the gluing station by oscillating a pair of reel supporting rolls.

[0026] A similar dispenser can be used for applying glue to the tubular cores on which the web is wound to form a reel, before the core is introduced in the rewinder.

[0027] It will be understood that the drawing shows only an illustrative embodiment provided purely by way of a practical demonstration of the invention, it being possible to vary said invention as regards shapes and arrangements, yet without departing from the scope of the concept underlying the invention. Any reference numerals in the accompanying claims are purely for facilitating the reading of the claims with reference to the description and to the drawing, and do not limit the scope of protection represented by the claims.

Claims

1. Device for gluing the tail end (LF) of a reel (L) of wound web material, comprising: conveying means (5, 21) for moving the reel; unwinding means (7, 9) for unwinding the tail end (LF) of the web material when said reel is in an unwinding position; a dispenser (11) of glue (C) for applying the glue to the reel (L), arranged downstream of said unwinding position; and means (21) for rewinding the tail end after the glue (C) has been applied; said dispenser (11) including an upwardly oriented slit (155) from which the glue is dispensed;

characterized in that

said dispenser (11) includes a container (151) for the glue with said upwardly oriented slit (155) and a moving member (157) positioned inside said container, which is immersed in the glue contained in the container (151) and moved towards said upwardly oriented slit (155) in order to dispense the glue to the reel as it rolls over said slit.

2. Device according to claim 1, wherein said container (151) is upwardly closed by a wall (153) forming a rolling surface (5) for said reel (L), said wall being provided with said upwardly oriented slit (155).
3. Device according to claim 1 or 2, wherein said moving member (157) is provided with an upper concave surface (157S), in which the glue to be dispensed through said slit is collected.
4. Device according to one or more of the preceding claims, wherein said moving member (157) is

formed by a transversal and substantially rectilinear bar (159).

5. Device according to one or more of the preceding claims, wherein said moving member (157) is supported by a set of rockers (165, 167) which are linked to a fixed structure (151) and controlled with an oscillating motion. 5
6. Device according to one or more of claims 1 to 4, wherein said moving member (157) rotates about a fixed transversal axis (183). 10
7. Method for gluing the tail end (LF) of a web material wound to form a reel (L), in which the tail end (LF) is detached from the surface of the reel and unwound from it to a predetermined length; the reel is rolled, with the tail end unwound therefrom, over a slit (155) from which glue (C) is dispensed, to apply said glue to a portion of the web material which is still wound up on the reel (L); and the tail end is re-wound onto the reel; 15
characterized in that
said glue is contained in a container (151) arranged under said slit (155) and is cyclically picked up by a moving member (157) arranged in said container, said moving member (157) bringing said glue (C) in correspondence of said dispensing slit (155) and being in its upper position when the reel (L) is made to roll over said slit (155). 20 25

Patentansprüche

1. Vorrichtung zum Ankleben des rückwärtigen Endes (LF) einer Rolle (L) aus aufgewickeltem Bahnmaterial mit Fördermitteln (5, 21) zum Bewegen der Rolle, Abwickelmittel (7, 9) zum Abwickeln des rückwärtigen Endes (LF) des Bahnmaterials, wenn sich die Rolle in einer Abwickelposition befindet, mit einem Spender (11) für Klebstoff (C) zum Auftragen des Klebstoffs auf die Rolle (L), der abstromseitig zur Abwickelposition angeordnet ist, und mit Mitteln (21) zum Wiederaufwickeln des rückwärtigen Endes nach dem Auftrag des Klebstoffes (C), wobei der Spender (11) einen aufwärts orientierten Schlitz (155) aufweist, aus welchem der Klebstoff abgegeben wird, 35
dadurch gekennzeichnet, daß
der Spender (11) einen Behälter (151) für den Klebstoff mit dem aufwärts orientierten Schlitz (155) sowie ein bewegliches Bauteil (157) aufweist, das innerhalb des Behälters positioniert ist und in den im Behälter (151) enthaltenen Klebstoff eingetaucht und zu dem aufwärts orientierten Schlitz (155) bewegt wird, um Klebstoff an die Rolle abzugeben, wenn sie über den Schlitz abrollt. 40 45 50

2. Vorrichtung nach Anspruch 1, in welcher der Behälter (151) nach oben von einer Wand (153) abgeschlossen ist, die eine Abrollfläche (5) für die Rolle (L) bildet und mit dem aufwärts orientierten Schlitz (155) versehen ist. 5
3. Vorrichtung nach Anspruch 1 oder 2, **dadurch gekennzeichnet, daß** das bewegliche Bauteil (157) mit einer oberen konkaven Oberfläche (157S) versehen ist, in welcher der durch den Schlitz abzugebende Kleber gesammelt wird. 10
4. Vorrichtung nach einem oder mehreren der vorstehenden Ansprüche, wobei das bewegliche Bauteil (157) von einem quer gerichteten und im wesentlichen gradlinigen Balken (159) gebildet ist. 15
5. Vorrichtung nach einem oder mehreren der vorstehenden Ansprüche, bei der das bewegliche Bauteil (157) von einer Gruppe von Armen (165, 167) getragen ist, die an eine feste Struktur (151) angelenkt und von einer oszillierenden Bewegung beaufschlagt sind. 20
6. Vorrichtung nach einem oder mehreren der Ansprüche 1 bis 4, bei der das bewegliche Bauteil (157) um eine feste Querachse (183) rotiert. 25
7. Verfahren zum Ankleben des rückwärtigen Endes (LF) eines Bahnmaterials, das zur Bildung einer Rolle (L) aufgewickelt ist, bei dem das rückwärtige Ende (LF) von der Oberfläche der Rolle abgenommen und von ihr um eine vorgegebene Länge abgewickelt wird, die Rolle mit dem abgewickelten rückwärtigen Ende über einen Schlitz (155), aus welchem Klebstoffe (C) abzugeben ist, abgerollt wird, um den Klebstoff auf einen Teil des Bahnmaterials aufzutragen, welches auf der Rolle (L) aufgewickelt ist, und bei dem das rückwärtige Ende auf die Rolle aufgewickelt wird, 30
dadurch gekennzeichnet, daß
der Klebstoff in einem Behälter (151) enthalten ist, der unter dem Schlitz (155) angeordnet ist und zyklisch von einem beweglichen Bauteil (157), das in dem Behälter angeordnet ist, aufgenommen wird, wobei das bewegliche Bauteil (157) den Klebstoff (C) in Entsprechung zu dem Abgabeschlitz (155) bringt und sich in seiner obersten Position befindet, wenn die Rolle (L) zum Rollen über den Schlitz (155) veranlaßt wird. 35 40 45 50

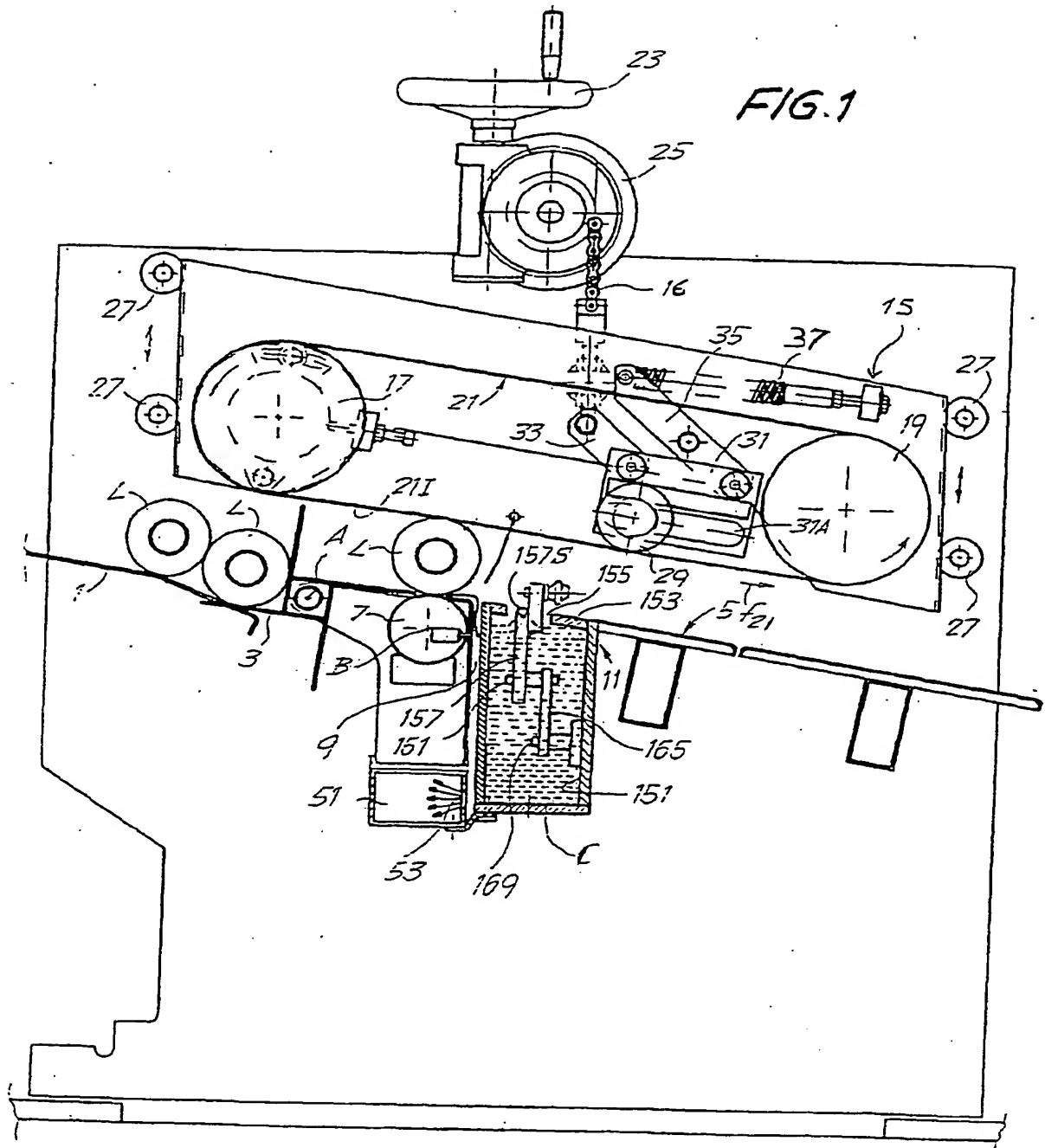
Revendications

1. Dispositif pour encoller l'amorce (LF) d'une bobine (L) de matériau en bande enroulé, comprenant : des moyens de convoyage (5, 21) pour déplacer la bobine ; des moyens de déroulage (7, 9) pour dé- 55

rouler l'amorce (LF) du matériau en bande lorsque la bobine est dans une position déroulée ; un distributeur (11) de colle (C) pour appliquer la colle sur la bobine (L) disposé en aval de ladite position déroulée ; et des moyens (21) pour ré-enrouler l'amorce après que la colle (C) a été appliquée ; le distributeur (11) comprenant une fente orientée vers le haut (155) à partir de laquelle la colle est distribuée ; **caractérisé en ce que** le distributeur (11) comprend un récipient (151) de colle présentant la fente orientée vers le haut (155) et un organe mobile (157) placé à l'intérieur du récipient, qui est immergé dans la colle contenue dans le récipient (151) et qui se déplace en direction de la fente orientée vers le haut (155) pour distribuer la colle sur la bobine lorsqu'elle roule au-dessus de la fente.

dans sa position supérieure lorsque la bobine (L) est amenée à rouler sur ladite fente (155).

2. Dispositif selon la revendication 1, dans lequel le récipient (151) est fermé vers le haut par une paroi (153) formant une surface de roulage (5) pour la bobine (L), la paroi comprenant la fente orientée vers le haut (155).
3. Dispositif selon la revendication 1 ou 2, dans lequel l'organe mobile (157) présente une surface concave vers le haut (157S) sur laquelle la colle à distribuer à travers la fente se rassemble.
4. Dispositif selon l'une des revendications précédentes, dans lequel l'organe mobile (157) est formé d'une barre transversale sensiblement rectilinéaire (159).
5. Dispositif selon l'une des revendications précédentes, dans lequel l'organe mobile (157) est supporté par un ensemble de culbuteurs (165, 167) qui sont reliés à une structure fixe (151) et contrôlés dans un mouvement oscillatoire.
6. Dispositif selon l'une des revendications 1 à 4, dans lequel l'organe mobile (157) tourne autour d'un axe transversal fixe (183).
7. Méthode pour encoller l'amorce (LF) d'un matériau en bande enroulé pour former une bobine (L), dans laquelle l'amorce (LF) est détachée de la surface de la bobine et déroulée sur une longueur prédéterminée, la bobine roule avec son amorce déroulée au-dessus d'une fente (155) à partir de laquelle la colle (C) est distribuée, afin d'appliquer la colle à une portion du matériau en bande qui est encore enroulé sur la bobine (L), et l'amorce est ré-enroulée sur la bobine, **caractérisée en ce que** la colle est contenue dans un récipient (151) disposé sous la fente (155) et est cycliquement prélevée par un organe mobile (157) disposé dans le récipient, l'organe mobile (157) apportant la colle (C) en correspondance avec la fente de distribution (155) et étant



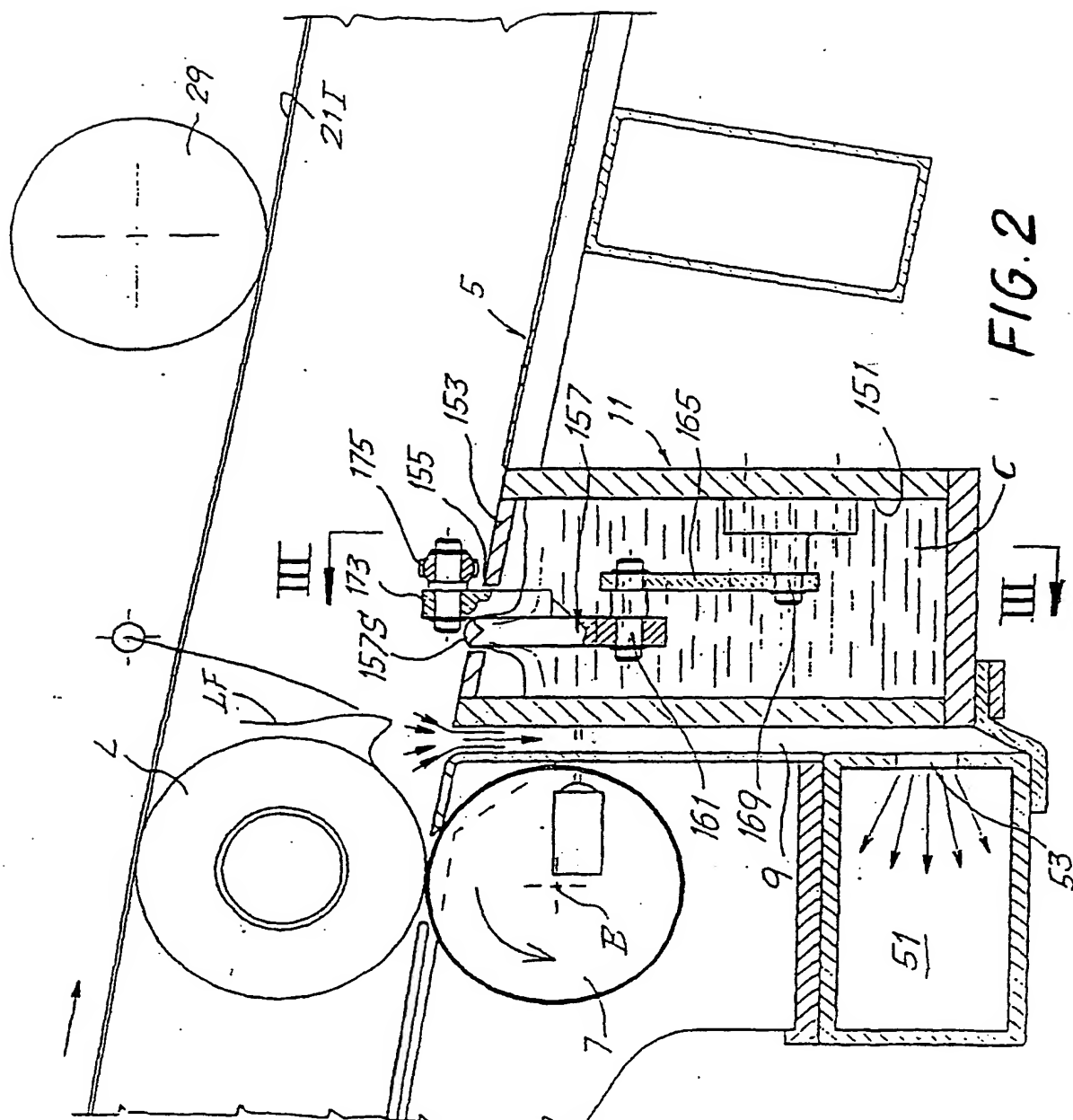


FIG. 2

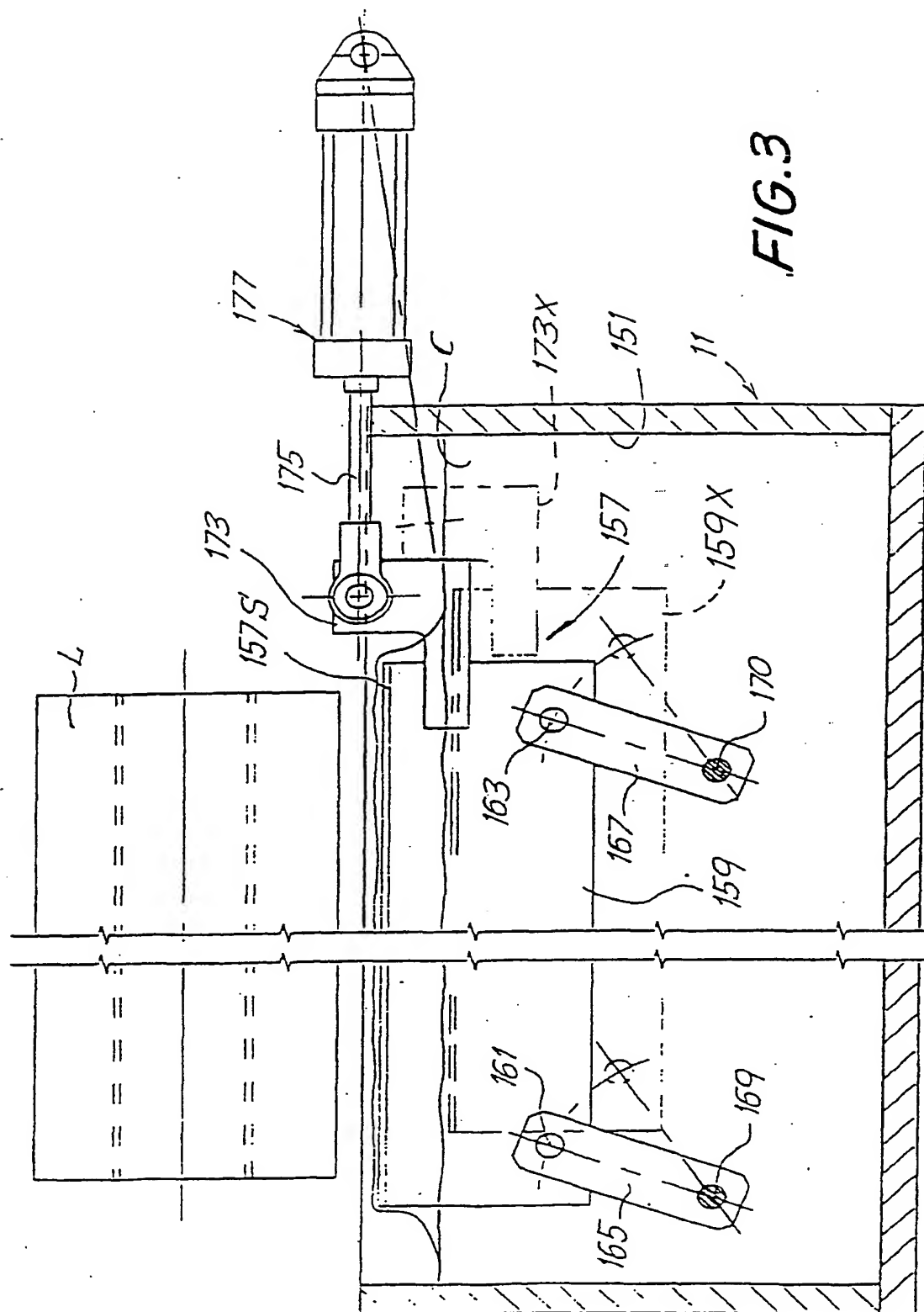
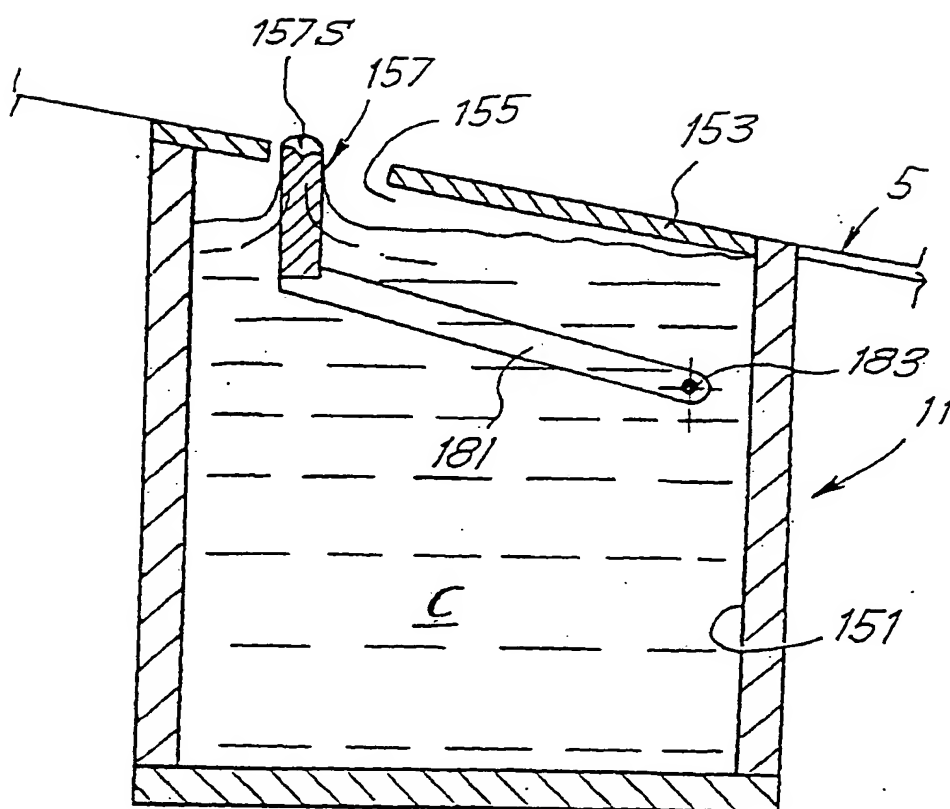


FIG. 3



**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ **BLACK BORDERS**
- ☐ **IMAGE CUT OFF AT TOP, BOTTOM OR SIDES**
- ☐ **FADED TEXT OR DRAWING**
- ☐ **BLURRED OR ILLEGIBLE TEXT OR DRAWING**
- ☐ **SKEWED/SLANTED IMAGES**
- ☐ **COLOR OR BLACK AND WHITE PHOTOGRAPHS**
- ☐ **GRAY SCALE DOCUMENTS**
- ☒ **LINES OR MARKS ON ORIGINAL DOCUMENT**
- ☒ **REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY**
- ☐ **OTHER:** _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.